

Work Order ID 133475

133475

Page 1

Monday, June 08, 2015 4:11:53 PM

Item ID: D4798-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 6/08/15 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/08/15 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: ML3

Date: JUN 09 2015 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4798	B

100

0.00

100

Waterjet

FLOW CNC Waterjet

304-063

Memo

1-Cut D4798-1 as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

4 0 JMIS-6-11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

4 0 JMIS-6-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>1</u> _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Lead hand / Supervisor Approval Verification	
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OTHER : ☐					

Work Order ID 133475

133475

Page 3

Monday, June 08, 2015 4:11:53 PM

Item ID: D4798-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 6/08/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/08/15 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 9 9-89
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>600</u>	0.00							
160									
Packaging	Memo	0.00							DAS 6 9-89
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MCS AUG 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
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OTHER : ☐					

Picklist Print

Page 1

Monday, June 08, 2015 4:11:53 PM

Work Order ID: 133475

133475

Parent Item: D4798-041

D4798-041

Parent Item Name: Wearplate Assembly

Start Date: 6/08/15

Required Date: 6/08/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13-03-26 JLM VERIFIED BY:DD IPP
REV:B 13.05.28 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4379-1		Manufactured	No				Each	66.0000		40			
---------	--	--------------	----	--	--	--	------	---------	--	----	--	--	--

D4379-1

Wearplate Cup

15-08-19

JBL

LocationLoc QtyLoc Code

WA002

66

129938

5

131032

21

132661

40

sf

240.3076

5
7
17
5

Jm15-6-11

M304S16GA

Purchased

No

M304S16GA

304/316 Sheet .063

LocationLoc QtyLoc Code

MAT019

240.3076

m131384

95.0176

m131503

145.29

131503

DQA: _____ Date: _____



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ITEM	QTY	P/N	DESCRIPTION
1	X	D4798-041	WEARPLATE ASSEMBLY
2	10	D4379-1	WEARPLATE CUP
3	1	D4798-1	WEARPLATE
4	A/R	2059B	HARDCOAT

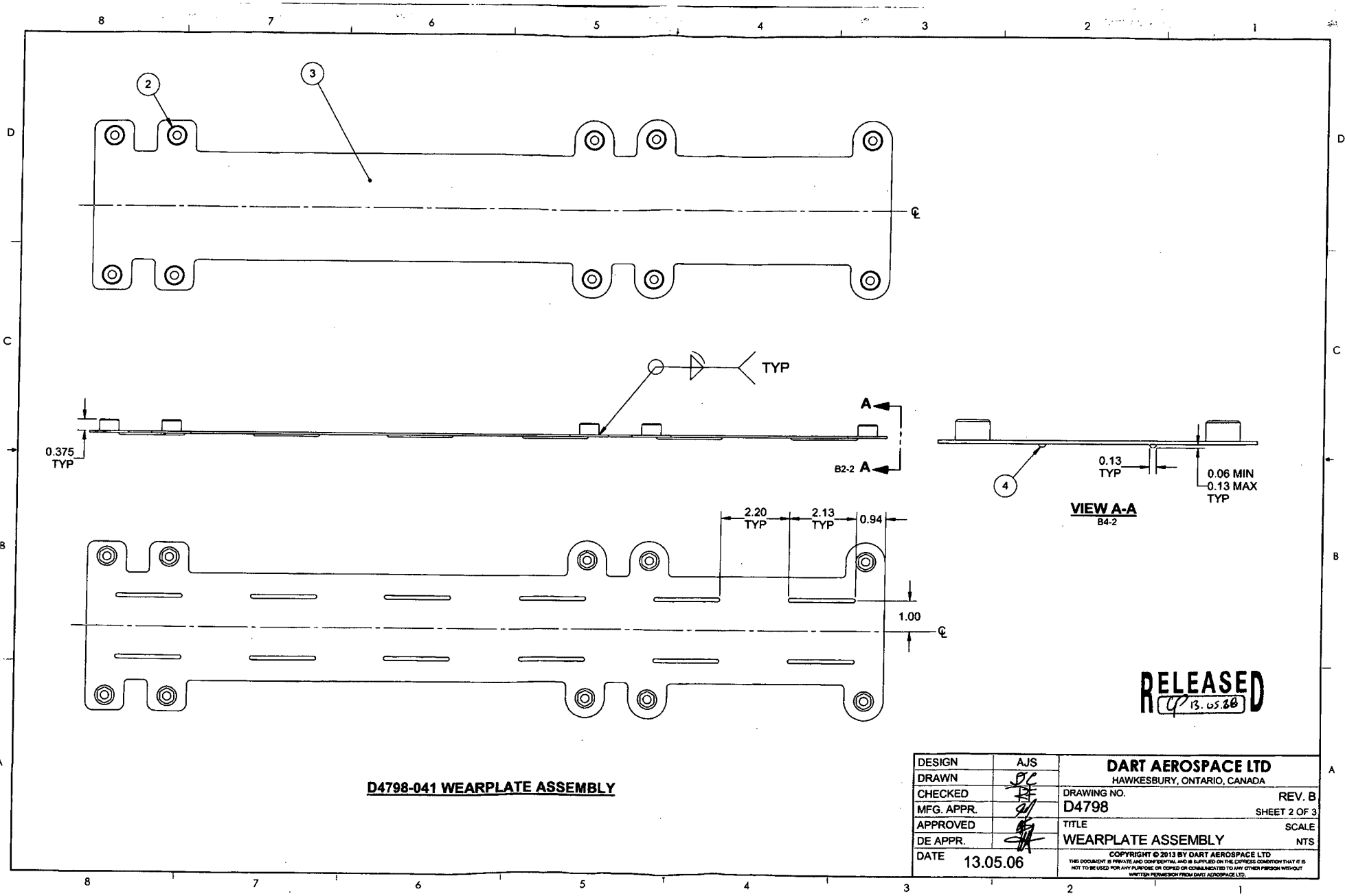
SLIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 133-475-MCS
15-06-09

D4798-041 WEARPLATE ASSEMBLY

RELEASED
ECN 13-0528
13-062

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 2.05 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 12 PL

B	5.79 WAS 6.19, 4.540 WAS 4.938, ZN C1-3, MODIFIED MOUNTING LUG GEOMETRY, ZN C7-3.	DC	13.05.06
A	NEW ISSUE	DC	13.03.20
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	PF	DRAWING NO.	REV. B
MFG. APPR.	8/	D4798	SHEET 1 OF 3
APPROVED	8/	TITLE	SCALE
DE APPR.	8/	WEARPLATE ASSEMBLY	NTS
DATE	13.05.06	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

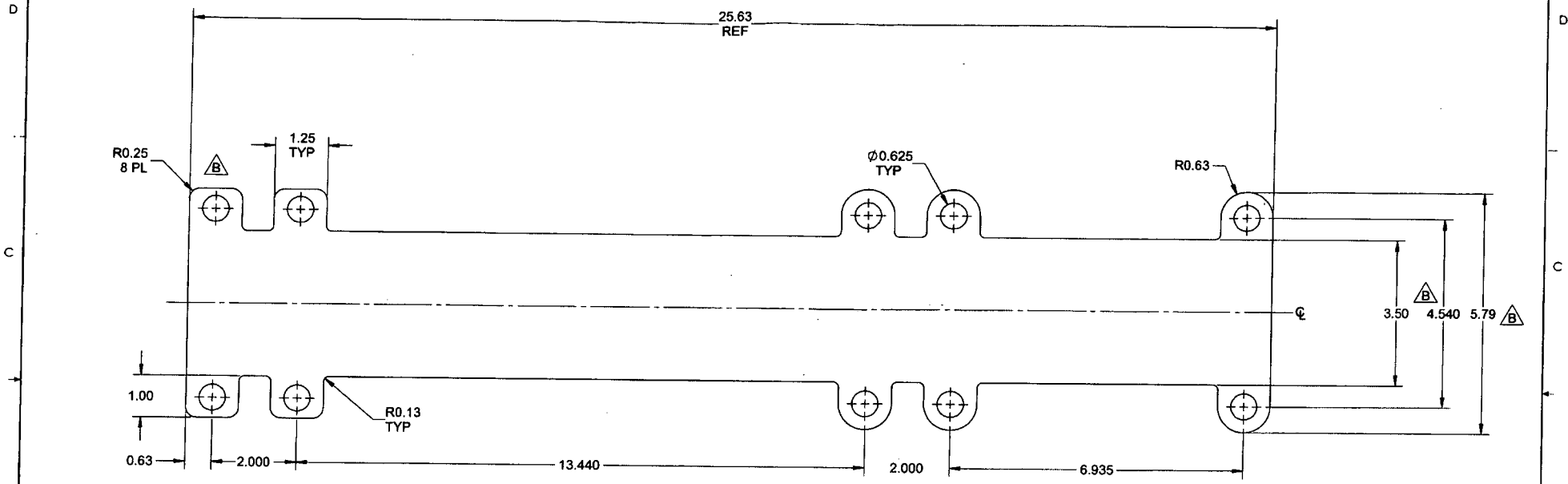


D4798-041 WEARPLATE ASSEMBLY

RELEASED
13.05.88

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DF	DRAWING NO. D4798	REV. B
MFG. APPR.	DF	SHEET 2 OF 3	
APPROVED	DF	TITLE WEARPLATE ASSEMBLY	SCALE NTS
DE APPR.	DF	DATE 13.05.06	
		COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



D4798-1 WEARPLATE

RELEASED
13.05.20

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.82 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4798	SHEET 3 OF 3
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	WEARPLATE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1